

**ULTEM™ Resin AR9110 - Americas**

PEI-GF10

Saudi Basic Industries Corporation (SABIC)

Processing/Physical Characteristics	Value	Unit	Test Standard
<b>ASTM Data</b>			
Melt Flow Index, MFI	<b>12.5</b>	g/10min	ASTM D 1238
Temperature	<b>337</b>	°C	-
Load	<b>6.6</b>	kg	-

Mechanical properties	Value	Unit	Test Standard
<b>ASTM Data</b>			
Tensile Modulus	<b>4480</b>	MPa	ASTM D 638
Tensile Strength at Yield	<b>106</b>	MPa	ASTM D 638
Tensile Strength at Break	<b>102</b>	MPa	ASTM D 638
Elongation at Break	<b>8</b>	%	ASTM D 638
Izod Impact notched, 1/8 in	<b>58</b>	J/m	ASTM D 256

Other properties	Value	Unit	Test Standard
Density	<b>1400</b>	kg/m <sup>3</sup>	ASTM D 792

Processing Recommendation Injection Molding	Value	Unit	Test Standard
Pre-drying - Temperature	<b>150</b>	°C	-
Pre-drying - Time	<b>4 - 6</b>	h	-
Processing humidity	<b>≤0.02</b>	%	-
Melt temperature	<b>365 - 390</b>	°C	-
Mold temperature	<b>135 - 165</b>	°C	-
Zone 1	<b>345 - 365</b>	°C	-
Zone 2	<b>355 - 375</b>	°C	-
Zone 3	<b>365 - 390</b>	°C	-
Screw speed	<b>40 - 70</b>	rpm	-
Back pressure	<b>0.3 - 0.7</b>	MPa	-

**Characteristics****Processing**

Injection Molding

**Regional Availability**

North America